



Dart Aerospace Ltd.
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D3914-041
Job Sheet 170722



Part No: D3914-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/18/18

Job Tracking No:

Due Date: 3/23/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/22/18	0.00	0.00	Start Up Large Fab-5		DC 2018-02-16
100	Large Fab	1 pcs		3/22/18	0.00	6.67	Large Fab 1		M 2018-02-16
110	QC	1 pcs		3/22/18	0.00	0.00	QC9		CPC
120	QC	1 pcs		3/22/18	0.00	0.00	QC5		CPC
130	Powdercoat	1 pcs		3/22/18	0.00	0.40	Powdercoat4		BR 18-2-22
135	QC	1 pcs		3/22/18	0.00	0.00	QC3		W 18-2-23
140	HandFinish	1 pcs		3/23/18	0.00	0.80	HandFinish3		W 18-2-23
150	QC	1 pcs		3/23/18	0.00	0.00	QC3		BB 18-02-23
160	Packaging	1 pcs		3/23/18	0.00	0.00	Packaging3-2		KL 18-2-20
170	QC21-SA	1 Ea		3/23/18	0.00	0.00	QC21		21 FEB 20 2018

Part Op 100 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg
Descriptions: D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where
label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label
plate before tacking mesh***

130 - *** mask sides of hinge prior to powdercoat***

140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask
label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

M138200 START: 4:30 OUT: 3:00 FINISH: 5:00 Wing walk M138761

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5033599
D3914-1	Rib	2 Ea (2 ea)	90-Start up Operation	5034699
D3914-7	Rib	2 Ea (2 ea)	90-Start up Operation	5039696
D4016-3	Hinge Half, Lid	3 Ea (3 ea)	90-Start up Operation	5038793
D4018-5	Rib	9 Ea (9 ea)	90-Start up Operation	5035012 X6
D4020-5	Mesh (350 Basket Long, Lid)	1 Ea (1 ea)	90-Start up Operation	5034504030 4
D4021-3	Data Plate	1 Ea (1 ea)	90-Start up Operation	5032438
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 Ea (2 ea)	90-Start up Operation	5041480
D2728-3	Dart Logo Label Large	1 (1 ea)	140-HandFinish	

Part Specifications

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
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Description Work Order	Under Deviation	Disposition
Master Unit 000925 Job No 170722 Job No 170722 Container No: S042770 Part: D3914-041 Serial No/Batch: S042770 Revision: D4020 Inspector: _____ Date: 02/15/10 1:45 PM Part: D3914-041 Serial No/Batch: S042770 Revision: D4020 Inspector: _____ Date: 02/15/10 1:45 PM		Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

FAULT CATEGORY		
Enviro	☐ Power Loss/Surge	☐ Positioned Wrong
I	☐ Folio/Program	☐ Outside Dimensions
Doc	☐ Grain	☐ Over/Under tolerance
Equip/T	☐ Weld	☐ Part Incorrect
Handli	☐ Wrong Stock Pulled	☐ Part Lost/Missing
Material	☐ Out of Sequence	☐ Part Moved
Internal Transport	☐ Off-set	☐ Drawing
Tribal Knowledge	☐ Misabeled	☐ Finish
LOA	☐ Fit/Function	☐ Misread
Substation	☐ Misaligned/off center	☐ Turning Sequence

Pressur

Bending

Centre No

Cracks

Crimp/Kink

Cuffs

Crushing

Heat Treat

Wave/Twist in T

Marks/Chatter

Drill Holes